Date: User:

Friday, 6/16/2006 1:36:55 PM

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 27566

Estimate Number P.O. Number

: 11174

: NIA

This Issue Prsht Rev.

First Issue

: 6/16/2006

: NC

: 6/15/2006 : 26932

Type

: PURCHASED PARTS

Previous Run Written By

Checked & Approved By

Comment

: Est. B 05.05.25

Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798

S.O. No. : NIA

EC

Drawing Name

: REPLACEMENT WINDOW ASSEMBLY

Part Number

. D3290 REV B **Drawing Number** : N/A

Project Number Drawing Revision

Material **Due Date** : NIA

: 7/5/2006

: D3290041

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

2.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.:

3.7500 sf(s)/Unit Total: 5052-H32 .040 Sheet

30.0000 sf(s)

COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIMENSIONAL CHECK

4.0

3.0

QC6

QC2

Comment: DIMENSIONAL

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

JAO

6.0

HAND FINISHING1

Deburr

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-09-12

\$ Friday, ₹8/16/2006 1:36:55 PM Date: 4 User: Linda Lacelle **Process Sheet Drawing Name: REPLACEMENT WINDOW ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D3290041 Job Number: 27566 Job Number: Seq. #: Description: **Machine Or Operation:** POWDER COATING 7.0 POWDER COATING **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 09 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 D2126 6.5000 f(s)/Unit Total: 52.0000 f(s) Comment: Qty.: Locking Seal Pick: Qty Part Number Description Batch D2126-0780 Locking Seal D32901 10.0 Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s) Window Frame Pick: Qty Description Part Number Batch 1 D3290-1 Window Frame D32903 11.0 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty.: Window Pick: Part Number Description B27090 D3290-3 Window 06:09:13 SMALL & MEDIUM FAB RESOURCE 1 12.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3290 06:09:13 SAD Clean D3290-041 and place in plastic wrap

িন্দাday, -8/16/2006 1:36:55 PM Date: -User: Linda Lacelle **Process Sheet** Drawing Name: REPLACEMENT WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 27566 Part Number: D3290041 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP QC5 13.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 14.0 **PACKAGING 1** Comment: PACKAGING RE Identify and Stock Location: DOCUMENT CONTROL 15.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

: REPLACEMENT WINDOW ASSEMBLY

Thursday, 6/15/2006 1:42:07 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 27566

Estimate Number

: 11174

P.O. Number

: 6/15/2006 This Issue

: NC

: // : 26932 S.O. No. :

: PURCHASED PARTS Type

Part Number

Drawing Name

: D3290041

Drawing Number

: D3290 REV B

Project Number

: N/A : B

Drawing Revision Material

Due Date

: 7/5/2006

Each

Previous Run Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

Added Step 11 KJ/JLM : Est. B 05,05/25

Est. C 06.05.09 Ecn 798 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:



Comment: PURCHASING

-- D32901F

4ssue P/O:-

PURCHASING

Manufacture D3290-1-as-per-Dwg D3290 (3.75 SF) M101875 (2)

Possible Supplier: GF1

Material-release-note-is-required

Batch: M15981 H17835 Window Frame

8.0000 U(s)



Comment: Qty.: 1.0000 U(s)/Unit Total Replacement Window Assy

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr



Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER C	ER CHANGES						
DATE STE						Approval Mfg / Design Mgr	Approval QC Inspector		
				·					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A	A		
DATE	STEP	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
2 2 2 Surp. Deep scrate in the mat!		2 parts surp. Deep scrattes in the mat!	1 Son	Destroy no replace.	26.03.33	6.06.23	6000	106 Sts 23		
			105							

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>odollô</u> .
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

· Thursday, 6/15/2006 1:42:07 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: REPLACEMENT WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3290041 Job Number: 27566 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Seal 9.0 D2126 l i Comment: Qty.: 52.0000 f(s) 6.5000 f(s)/Unit Total: Locking Seal Pick: Qty Part Number Description Batch 1 D2126-0780 Locking Seal 10.0 D32901 Window Frame Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s) Window Frame Pick: Qty Description Batch Part Number D3290-1 Window Frame 1 11.0 D32903 Window Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Window Pick: Qty Part Number Description Batch D3290-3 Window

erospa	ce Ltd							
		W	ORK ORDER CHANGES		· · · · · · · · · · · · · · · · · · ·			
STEP	PR	PROCEDURE CHANGE					Approval Mfg / Design Mgr	Approval QC Inspector
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		WORK ORD	ER NON-CONFORMANC	E (NCI	₹)			
	Description of NC		Corrective Action Section B		Vorifi	antion	Annuaral	Annroval
STEP	Section A	Initial Design Mgr	Action Description Design Mgr		& Sect		Design Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date:
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

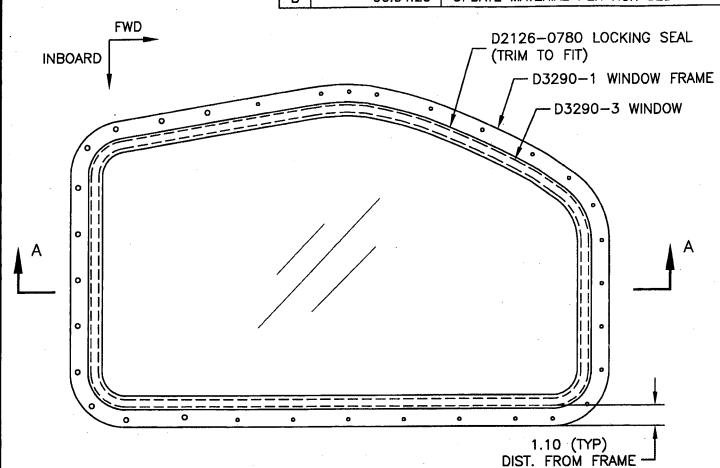
Date: Thursday, 6/15/2006 1:42:07 PM User: Kim Johnston **Process Sheet** Drawing Name: REPLACEMENT WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3290041 Job Number: 27566 Job Number: Seq. #: Description: Machine Or Operation: SMALL & MEDIUM FAB RESOURCE 1 12.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap INSPECT WORK TO CURRENT STEP QC5 13.0 Comment: INSPECT WORK TO CURRENT STEP 14.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DOCUMENT CONTROL 15.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

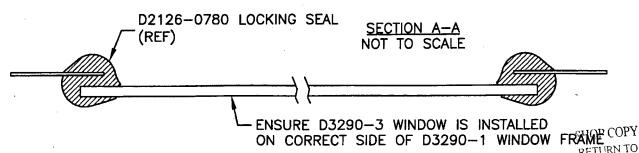
Dart Aerospace Ltd

W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	STEP PROCEDURE CHANGE					Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
							•			
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFO	ORMANC	E (NCR	2)			
DATE	OTED	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
	STEP	Section A	Initial Design Mgr	Action Descrip Design Mgr	otion	Sign & Date	Section		Design Mgr	QC Inspector
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Part No):	PAR #:	Fault Category	/:	NCR: Ye	s No	DQA:	·	Date:	
NOTE: D	ate & initia	al all entries			QA	A: N/C CI	osed:		Date:	



DESIG	n RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	Ī
CHECK	ŒD ,	APPROVED ,	DRAWING NO. R	REV. B
	-4	#	D3290 SHEET 1	OF 3
DATE		L	TITLE	SCALE
06.0	04.20		REPLACEMENT WINDOW ASSEMBLY	1:5
Α		04.06.14	NEW ISSUE	
R		06.04.20	UPDATE MATERIAL PER NCR 029	





D3290-041

NOTES

1) ALL DIMENSIONS ARE IN INCHES

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NGINEERING WITH TOTICE

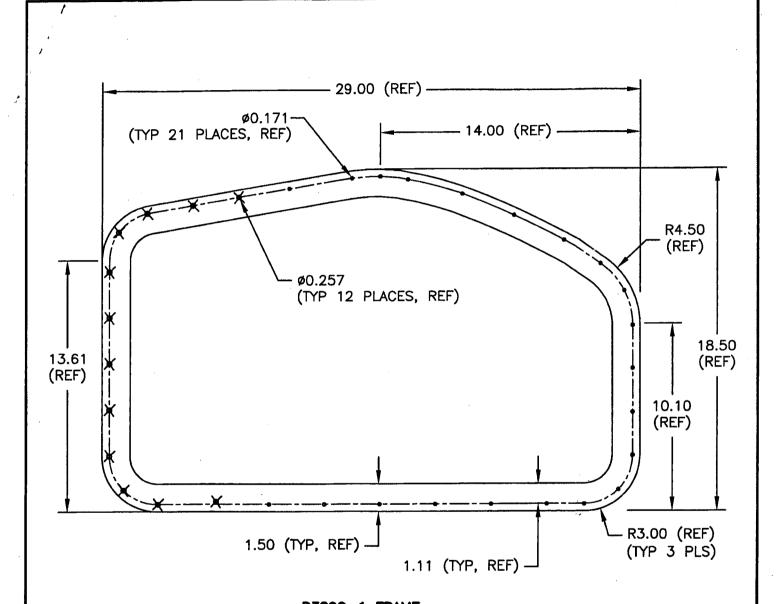
EDGE TO WINDOW

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CHECKED	APPROVED	DRAWING NO.	REV. B
一概	#	D3290 SHEET	2 OF 3
DATE		TITLE	SCALE
06.04.20		REPLACEMENT WINDOW ASSEMBLY	1:5



D3290-1 FRAME

D3290-1

1) MACHINE PER DRAWING FILE "D3290-A2.DWG"

2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK

3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PELEAS

UNCONTROLLED CO

SUBJECT TO AMENDMEN WITHOUT NOTICE

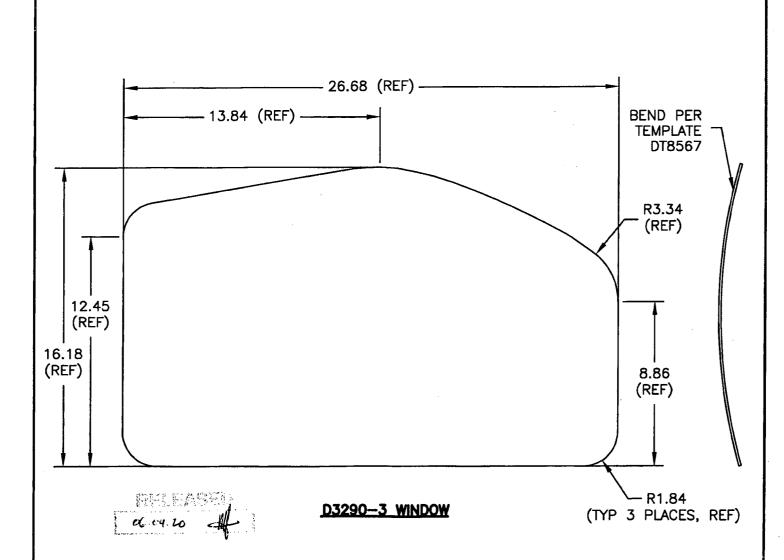
WORK ORDER

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DESIGN RF	DRAWN BY	DART AEROSPACE LTI HAWKESBURY, ONTARIO, CANADA	D
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3290 SHE	ET 3 OF 3
DATE		TITLE	SCALE
06.04.20	_	REPLACEMENT WINDOW ASSEMBLY	1:5



D3290-3

B 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 SHOP COPY

OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK

RETURN TO **ENGINEERING**

(REF. DART SPEC. M-ACRYLIC-S.125)

UNCONTROLLED COPY

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) CHECK PART USING DT3290-3T1

WORK ORDER

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DART AEROSPACE LTD	Work Order:	27566
Description: WINDOW FRAME	Part Number:	D3296
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.000	t0.010	29,000			measuring tape measuring top	
14.000	+0.010	14,000	レ		and vern	
60,171	\$0+0,005	00.175	/		Vern	
13.61	10,030	13.55	V		Vertical Vern	
1.50	to.030	1.501			Vern	
1, 11	\$0.010	1.113	<i>i</i>		Vern	
10,10	±0.030	10.09	/		vertical vern	·
18.50	±0.030	18.50	V		measuring tape	
0.040	+0,010	0.038			Vern	
R 3.00	+ 0.030	R3.00			17-6	
R4,50	t0.030	R4.50	V		R-6	
Ø 0.257	+0070	80.261	<u> </u>	, ,	Vern	
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Measured by:	<ad< td=""><th>Audited by:</th><th>_</th><th>Prototype Approval:</th><td></td></ad<>	Audited by:	_	Prototype Approval:	
Date: 06	:08:30	Date:	608.23	Date:	

	Rev	Date	Change	,	<u> </u>	7.4		Revised by	Approved
	A		New Issue		Po	3290-04	`	KJ/JLM	
- i	للتنا								

